



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7820

Job Sheet 202689



Part No: 647.7820

Job Qty: 16 pcs

Part Name: Cross Bracket Aft



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/19

Job Tracking No:

Due Date: 12/2/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev A New Issue JFS 15/04/29 Verified by: JLM

Ship Via:

Bill of Materials

Routing

Op No	Operation	Qty	S*	e	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	16			0.00	0.80	Bandsaw - 1		12-03-25
		pcs							
110	HAAS 5 Axis - B4B	16			0.75	126.25	HAAS - 5 - B4B		12-03-23
		pc							
120	QC 1				0.00	0.00	QC 1 - 14		
							QC 1 - 35		
							QC 1 - 8		Be 20-04-28
							QC 1 - 9		
130	QC 8				0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		Be 20-04-28
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		



Container No: S265964



Part: 647.7820

Job No: 202689

Serial No/Batch: S265964

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/24/20

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				QC 8 - 57		
				QC 8 - 76		
				QC 8 - 61		
140	Outsource - 4 - Anodize	16	12/2/19		ATG001-VC	10
		pcs				
150	Packaging 2-1 - Receive - B4B	16	12/2/19	0.00	0.00	Packaging 2 - 1 - B4B
		pcs				Packaging 2 - 2 - B4B
						Packaging 2 - 3 - B4B
						Packaging 2 - 5 - B4B
						Packaging 2 - 4 - B4B
						Packaging 2 - 6 - B4B
						Packaging 2 - 7 - B4B
						Packaging 2 - 8 - B4B
						Packaging 2 - 9 - B4B
						Packaging 2 - 10 - B4B
						Packaging 2 - 11 - B4B
						Packaging 2 - 12 - B4B
						Packaging 2 - 13 - B4B
						Packaging 2 - 14 - B4B
						Packaging 2 - 15 - B4B
						Packaging 2 - 16 - B4B
						Packaging 2 - 17 - B4B
						Packaging 2 - 18 - B4B
						Packaging 2 - 19 - B4B
						Packaging 2 - 20 - B4B
						Packaging 2 - 21 - B4B
						Packaging 2 - 22 - B4B
						Packaging 2 - 23 - B4B
						Packaging 2 - 24 - B4B
						Packaging 2 - 25 - B4B
						Packaging 2 - 26 - B4B
						Packaging 2 - 27 - B4B
						Packaging 2 - 28 - B4B
						Packaging 2 - 29 - B4B
						Packaging 2 - 30 - B4B
						Packaging 2 - 31 - B4B
						Packaging 2 - 32 - B4B
						Packaging 2 - 33 - B4B
						Packaging 2 - 34 - B4B

2020-05-06

MAY 21 2020

155 QC 5	16 pcs	12/2/19	0.00	0.00	Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DAS
					QC 5 - 61	82
					QC 5 - 81	9-89
180 Packaging 3-1 - Stock - B4B	16 pcs	12/2/19	0.00	0.00		MAY 29 2020
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	DAS
					Packaging 3 - 8 - B4B	28
					Packaging 3 - 9 - B4B	9-89
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	

				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	16 pcs	12/2/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-09

JUN 01 2020

Part Op 100 - Cut Blank at 14.900"

Descriptions: 110 - HAAS 5 Axis (HAAS CNC vertical machine #5) 1-Machine per folio FB376 DWG REV: A FOLIOREV: AA 2- Deburr and break all sharp edges

120 - (QC1- Inspection performed by CMM) QC1- Inspection performed by CMM Inspect on CMM as per folio CMMA003.

DWG REV: A CMM PROG. REV: A

130 - (QC8- Inspect parts - second check) QC8- Inspect parts - second check

140 - Outsource process-Anodize per QSI017 4.1.10.1 Issue P/O TO ATG: 46402 Anodize & prime as per Dwg. 647.7800

150 - (Receive & Inspect for Damage & Mat'l Certs) Receive & Inspect for Damage & Mat'l Certs

155 - (QC5- Inspect part completeness to step on W/O) QC5- Inspect part completeness to step on W/O

180 - (Identify as per dwg & Stock Location:) Identify as per dwg & Stock Location: ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release) QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.750X2.250	7075-T6 Sheet 1.750" X 2.250"	19.8720 ft (1.242 ea)	100-Bandsaw - 1	5 136957 → 13.36 5 107087 → 8

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S1.750X2.250	20	128	0

Part Specifications

Specifications could not be found.

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Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			



Dart Aerospace Ltd.
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PURCHASE ORDER

POHB046402



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046402

PO Date: 5/6/20

Due Date: 5/22/20

Purchase Order

Revision:

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	208108	647.0111	647.0100 Rev B	Panel : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed X10	-	5/22/20	10 pcs	0 pcs	10 pcs	\$40.43/pcs	\$404.30
2	202639	647.7820	647.7800 Rev A	Cross Bracket Aft : Various STC's Outsource process-Anodize per QSI017 4.1.10.1 Issue P/O TO ATG: Anodize & prime as per Dwg. 647.7800	Firmed X16	-	5/22/20	16 pcs	0 pcs	16 pcs	\$12.43/pcs	\$198.88

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9-89

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PURCHASE ORDER POHB046402



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	207896	647.1715	647.1700 Rev E	Plate : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.1700 Rev. E	Firmed X12	-	5/22/20	12 pcs	0 pcs	12 pcs	\$31.43/pcs	\$377.16
									MAY 15 2020			
4	205930	647.1710	647.1700 Rev E	Plate : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed X12	-	5/22/20	12 pcs	0 pcs	12 pcs	\$31.43/pcs	\$377.16
									MAY 15 2020			
5	20878	649.5112	649.5100 Rev D	RH Wiper Deflector : Various STC's Issue P/O to ATG AS PER DWG 649.5100 1- Black Anodize 2- PRIME, SEE NOTE #2 Certification of Conformity is required	Firmed X8	-	5/22/20	8 pcs	0 pcs	8 pcs	\$17.48/pcs	\$139.84

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PURCHASE ORDER

POHB046402



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	208887	D4970-5	D4970 Rev C	Doubler : Certificate of Conformity Only Issue P/O to ATG : FINISH: HARD BLACK ANODIZE AS PER IAW MIL- A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL- P-23377J TYPE 1 CLASS N	Firmed X8.	-	5/22/20	8 pcs	0 pcs	8 pcs	\$7.93/pcs	\$63.44
									MAY 11 2020			
8	208319	D4838-2	D4838 Rev A	Upper Cutter Body, RH : Certificate of Conformity only Issue P/O: ATG, black anodize and prime as per dwg D4838-2 Rev. A	Firmed X12	-	5/22/20	12 pcs	0 pcs	12 pcs	\$11.43/pcs	\$137.16
									MAY 15 2020			
9	207948	RBEL135M- 2905-101- 01	RBEL135M-2905-101 Rev 9	Case Outsource process- Anodize per QSI017 4.1.10.1 -Issue P/O -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed X3.	-	5/22/20	3 pcs	0 pcs	3 pcs	\$16.18/pcs	\$48.54
									MAY 11 2020			
10	209039	649.8310	649.8300 Rev N/C	Cutter Body : Various STC's Outsource process- Anodize per QSI017 4.1.10.1 Issue P/O to ATG : 1- Black Anodize as per Dwg 646.9700 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required	Firmed X5	-	5/22/20	5 pcs	0 pcs	5 pcs	\$15.68/pcs	\$78.40
									MAY 15 2020			

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PURCHASE ORDER **POHB046402**



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
11	206323	646.3310	646.3300 Rev A	LH Half - Upper Cutter Assembly : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : 1- Black Anodize as per Dwg 646.3300	Firmed 420		5/22/20	20 pcs MAY 21 2020	0 pcs	20 pcs	\$19.28/pcs	\$385.60
Grand Total:												\$2,210.48

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Handwritten signature: H. Guerin

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920160

Date: 20-May-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
16 ea	Part: 647.7820 Cross Bracket Aft Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 5265778 Job: 27454 PO: POHB046402	Rev: A	DAS 82 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: MAY 20 2020 Certified Signature: Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.		RECEIVED MAY 20 2020 DART AEROSPACE LTD.	

Made in Canada.